

Delete line 14 on page 8, and replace with the following:

--Useful austenitizing temperature and time ranges are about 1475°F to about 1625°F--

In the Claims:

1. (Amended) A process for forming a metal cylindrical bearing roller, said process comprising the steps of:

obtaining a hardened metal cylindrical blank having end face surfaces, a lateral surface defining an outer diameter, and a centered circular bore, said bore having an inner surface defining an inner diameter;

hard turning the inner surface of the bore having a specified inner diameter, thereby forming an inner bearing surface; and

hard turning the lateral surface of the blank to a specified outer diameter, thereby forming an outer bearing surface concentric with said inner bearing surface.

2. (Amended) The process of claim 1 wherein said hard turning the lateral surface of the blank further includes forming a radial crown.

9. (Amended) The process of claim 1 wherein said hard turning said lateral surface is carried out using a computer numerically controlled (CNC) lathe.

A marked-up copy of the claims is attached.

Add the following new claims:

12. (New) The process of claim 9 wherein said lathe comprises a cubic boron nitride or ceramic cutting tool.

13. (New) The process of claim 1 wherein said hard turning the lateral surface of the blank is carried out in a single operation.

14. (New) The process of claim 1 wherein said end face surfaces of said cylindrical blank comprise end face surfaces of said cylindrical bearing roller.